

Work Order ID 58358

May 4, 2010 10:13:54 AM

PRELIMINARY ISSUE



Page 1

Item ID: D3262-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 5/04/10 Start Qty: 10.00



Cust Item ID:

Required Date: 5/05/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3262

DE

100



Bandsaw

BAND SAW

0.00

aml 10/05/05

10 0

0.00

Memo

Cut blanks: 6.000" x 0.500" x 5.400" long Bar

110



HAAS 1

HAAS CNC VERTICAL MACHINING #1

0.00

0.00

Memo

Machine as per dwg D3262  
Machine as per Folio FA902 and Dwg D3262  
FOLIO REV: AA  
DWG REV: D  
Deburr

HAAS CNC vertical machine #1

10/05/06

10/05/08

10 0

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Page 2

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Run Start

Stop

QC:

Date:

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Date:

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Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
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Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

- to PEI

Done only

8/25/10 nco

- later with test fitting (green + no block)

140

Identify as per dwg & Stock Location

0.00

Packaging

Memo

0.00

Packaging

QC APPROVAL

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Page 3

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Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/12

MF 10-5-11

POSITIVE RECALL  
EFFECTIVE 10-5-04 AUTH   
RELEASED DATE 10-5-12

# Picklist Print

May 4, 2010 10:13:53 AM

Page 1

Work Order ID: 58358

Parent Item: D3262-5

Parent Item Name: Cap

Comments: IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC

Start Date: 5/04/10

Required Date: 5/05/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased	No			100	f	40.5945	0.96			



6061-T6 Bar .500 x 6.00



Location

Loc Qty

Loc Code

MAT05

40.5945

110912

0.5945

112567

40

→ 4.725' on 10/6/05

DART AEROSPACE LTD		Work Order: 58358
Description: Cap		Part Number: D3262-5
Inspection Dwg: D3262	Rev: <del>74</del> PE1 → New Rev E - diams good	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.45	±0.030	0.436	✓			
0.25	±0.030	0.249	✓			
Ø0.875	±0.010	0.876	✓			2PL
Ø5.005	+0.010/-0.000	5.005	✓			
R0.063	±0.010	0.062	✓			TYP
0.080	±0.010	0.079	✓			TYP
0.13	±0.030	0.13	✓			TYP
0.070 x 45°	±0.010 / ±1/2°	0.065 x 45°	✓			chamfer
Ø5.165	±0.010	5.168	✓			REF
1.63	±0.030	1.63	✓			
3.25	±0.030	3.25	✓			REF
9/16-18 UNF-3B	N/A					
3/4-16 UNF-3B	N/A					
0.091	+0.007/-0.008	0.090	✓			
R0.03	±0.010	0.03	✓			
R0.02	+0.000/-0.01	0.02	✓			
45°	±1/2°	45°	✓			
30°	±1/2°	30°	✓			
Ø0.588	+0.005/-0.000	0.591	✓			
Ø0.696	+0.007/-0.008	0.696	✓			

Measured by: <i>JJA</i>	Audited by: <i>[Signature]</i>	Prototype Approval: N/A
Date: 10/05/06	Date: <del>10/05/06</del>	Date: N/A

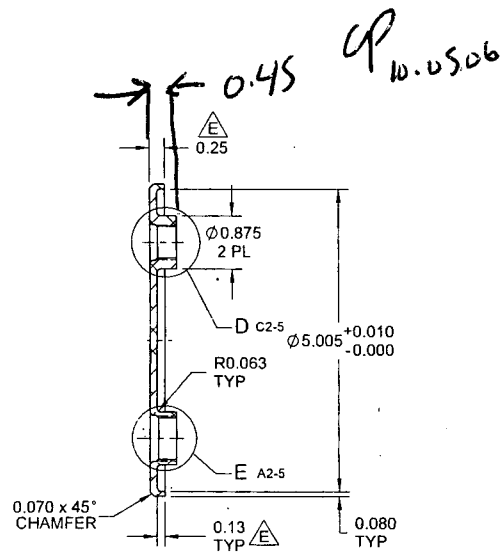
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

*8/10/10 to PE1 Prelim. Draw on by*

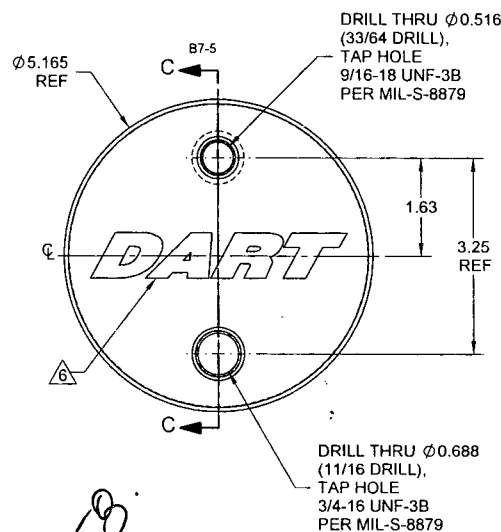
## FIRST ARTICLE INSPECTION CHECKLIST

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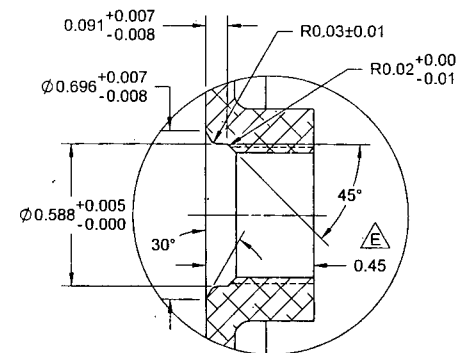
H:\FORMS\Quality Assurance\approved QA\FAI revD



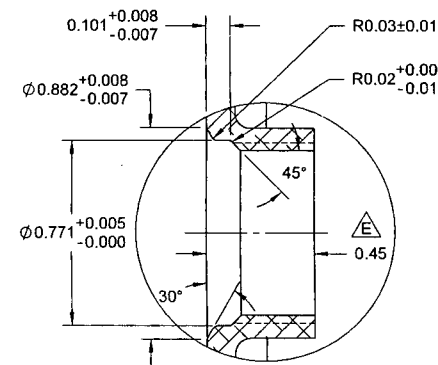
**SECTION C-C** D5-5



**D3262-5 CAP**



**DETAIL D** C7-5  
SCALE 2X



**DETAIL E** B7-5  
SCALE 2X

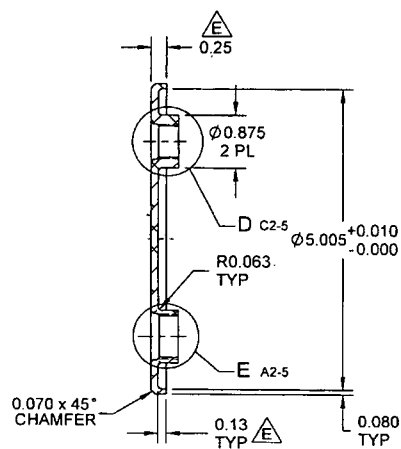
**NOTES:**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR  
PER QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP  
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.27 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

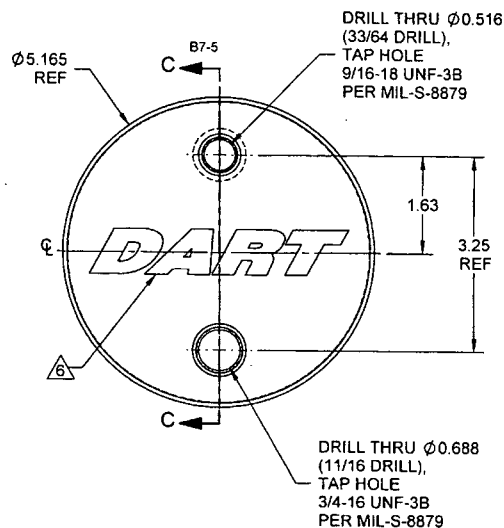
**PRELIMINARY ISSUE**

10.05.03

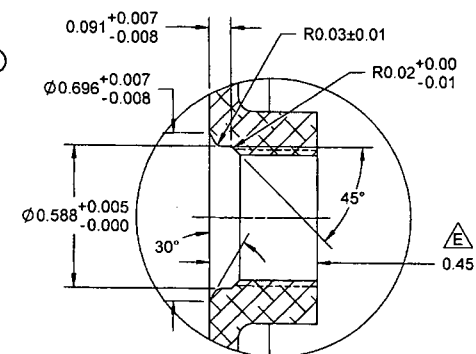
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		<b>D3262</b>	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>FUEL PURGE CANISTER</b>	NTS
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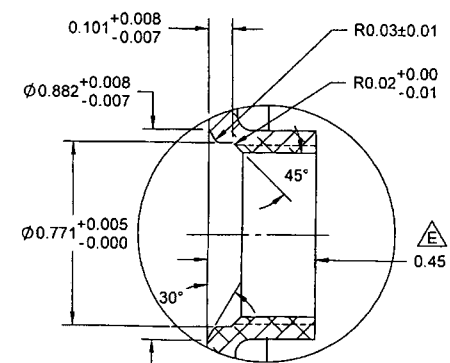
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	<b>D3262</b>	SHEET 5 OF 5
APPROVED	RF	TITLE	SCALE
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**RELEASED**  
2010-05-07  
NN



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries